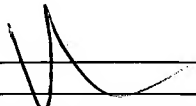


Date: Friday, 30/05/2008 10:48:39 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT FACING SEAT ASS'Y RH	
Job Number : 39610		
Estimate Number : 13314		
P.O. Number :	Part Number : D412769042	FOR ENGINEERING USE ONLY 01.06.06
This Issue : 30/05/2008 S.O. No. :	Drawing Number : D412-769-042 PROTO	
Prsht Rev. : NC	Project Number : N/A	
First Issue : 30/05/2008 Type : R & D SM/MED FAB	Drawing Revision : PROTO	
Previous Run :	Material :	
Written By : 	Due Date : 06/06/2008	Qty: 1 Um: Each
Checked & Approved By :		
Comment : Est rev A 08.05-12 new issue DD verified by:ec		

Additional Product

PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0	D3782045	Back Leg Assembly
-----	----------	-------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Back Leg Assembly
 batch: 305011

080530

3.0	D3782041	Front Inboard Leg Assembly
-----	----------	----------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Front Inboard Leg Assembly
 batch: 305014

080530

4.0	D3782044	Front Outboard Leg Assembly, RH
-----	----------	---------------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Front Outboard Leg Assembly, RH
 batch: 305012

080530

5.0	D3783041	Lateral Brace Assembly
-----	----------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Lateral Brace Assembly
 batch: 305005

080530

Date: Friday, 30/05/2008 10:48:39 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 39610

Part Number: D412769042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D3783043

Longitudinal Brace Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Longitudinal Brace Assembly

batch: B05006

✱

080530

7.0

D3783045

Angle Brace Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Angle Brace Assembly

batch: B05007

✱

080530

8.0

D3784041

Seat Support Assembly, Center



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, Center

batch: B05010

✱

080530

9.0

D3784043

Seat Support Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, LH

batch: B05009

✱

080530

10.0

D3784044

Seat Support Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, RH

batch: B05008

✱

080530

11.0

D37662

Front Rail, RH



D37712



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Front Rail

batch: B39531

✱

080530

12.0

D37663

Rear Rail



D37713



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rear Rail

batch: B39532

✱

080530

Date: Friday, 30/05/2008 10:48:39 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 39610

Part Number: D412769042

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D37671

Upper Rail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Upper Rail

batch:

338866

AA

080530

14.0

D37921

Seat Belt Eye Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Seat Belt Eye Bolt

batch:

REF BELL S/N 30856

USE

BHT PN 205-070-725-011

AA 080603

15.0

AN45 13A

EYE BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

EYE BOLT

batch:

M107938

AA

080530

16.0

AN415A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch:

M107321

AA

080530

17.0

NAS1149F0563P

Washer



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Washer

batch:

M108099

AA

080530

18.0

NAS1149F0463P

Washer



AN 960 - 416



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch:

M5519

AA

080530

19.0

AN515A

Bolt



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Bolt

batch:

M108077

AA

080530

Date: Friday, 30/05/2008 10:48:39 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 39610

Part Number: D412769042

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN510A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: M107013

080530

21.0

AN513A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M107321

080530

22.0

MS21042L5

Nut



Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

Nut

batch: M107464

080530

23.0

MS21042L4

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: 106051

080530

24.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble as per dwg D412-769-042

080530

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

080530

26.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-mask D3787-1 foot and around area of red powder coat as per dwg D412-769-042

2-Powder coat only D3782-041 and D3782-043 front legs in red as per dwg D412-769-042

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

N/A 08.06.07

Date: Friday, 30/05/2008 10:48:39 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 39610

Part Number: D412769042

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

27.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

28.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- mask D3782-041 and D3782-043 front legs and D3787-1 foot as per dwg D412-769-042

2- Powder coat remainig of assembly grey as per dwg D412-769-042

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

N/A
For
test
PLA
06.05.09

29.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0

D37742 03774-1

Seat Bottom, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Bottom, RH

batch: B39703

[Signature]

06.06.06

32.0

D37744 03774-3

Seat Back, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Bottom, RH

batch: ~~B39703~~

[Signature]

06.06.06

~~080604~~

B39704

Date: Friday, 30/05/2008 10:48:39 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 39610

Part Number: D412769042

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

AN52510R24

Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Screw

batch: ~~M105953~~

~~AN52510R24~~ AN52510R22

~~080603~~ 080603

34.0

NAS1149F0363P

Washer



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Washer

batch: ~~N5519~~

AN 960-10

~~080603~~ 080603

35.0

MS21042L3

Nut



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut

batch: ~~M107644~~

~~080603~~ 080603

36.0

AN35A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: ~~M100188~~

~~080603~~ 080603

37.0

D412724041

Head Rest Assembly, Center



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Head Rest Assembly, Center

batch: ~~B38956~~ B38956

~~080604~~ 080604

38.0

D412724044

Head Rest Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Head Rest Assembly, RH

Batch: ~~B38958~~ B38958

~~080604~~ 080604

39.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- install remaining parts as per dwg D412-769-042

~~080604~~ 080604

Date: Friday, 30/05/2008 10:48:39 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 39610

Part Number: D412769042

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

QC5

INSPECT WORK TO CURRENT STEP



PTO
08.08.08

Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL

41.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A.

42.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.06.06. Prototype

Job Completion



change to W/O # 00186 11 08/06/11

ANS25 10R22 (M107936) screws used at locations
that interfere with installation of D3774-1 Seat Bottom
and D3774-3 Seat back.

605t-16 Tubing installed at these locations to
compensate for $\phi 3/16$ hole to $\phi 3/16$ hole.

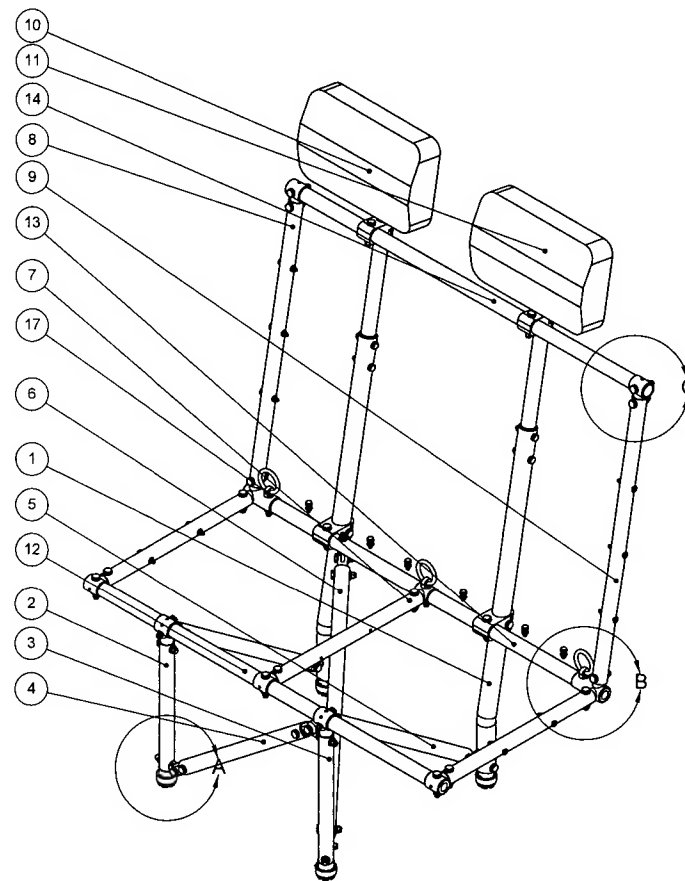
M521042 nut (M107644)

17N9605D106 washer (M104885)

~~Ref~~
08-08-05

Accounted
on
mat'l
req
form

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	D3782-045	BACK LEG ASSY	2
2	D3782-041	FRONT INBOARD LEG ASSY	1
3	D3782-044	FRONT OUTBOARD LEG ASSY, RH	1
4	D3783-041	LATERAL BRACE ASSY	1
5	D3783-043	LONGITUDINAL BRACE ASSY	2
6	D3783-045	ANGLE BRACE ASSY	1
7	D3784-041	SEAT SUPPORT ASSY	1
8	D3784-043	SEAT SUPPORT ASSY, LH	1
9	D3784-044	SEAT SUPPORT ASSY, RH	1
10	D412-724-041	HEAD REST ASSY, CENTER	1
11	D412-724-044	HEAD REST ASSY, RH	1
12	D3766-2	FRONT RAIL, RH	1
13	D3766-3	REAR RAIL	1
14	D3767-1	UPPER RAIL	1
15	D3774-1	SEAT BOTTOM	1
16	D3774-3	SEAT BACK	1
17	D3792-1	SEAT BELT EYE BOLT	3
18	AN45-13A	EYE BOLT	1
19	AN5-10A	BOLT	6
20	AN5-13A	BOLT	2
21	AN5-15A	BOLT	9
22	AN4-15A	BOLT	2
23	AN3-5A	BOLT	6
24	AN525-10R24	SCREW	10
25	MS21042L3	NUT	16
26	MS21042L4	NUT	2
27	MS21042L5	NUT	21
28	NAS1149D0363J	WASHER (AN960JD10)	22
29	NAS1149D0463J	WASHER (AN960JD416)	4
30	NAS1149D0568J	WASHER (AN960JD516)	38



PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

08.06.06 PB

8

D412-769-042 AFT FACING SEAT, RH

A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS		
DRAWN	HS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.06.04		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A
DRAWING NO. D412-769-2		SHEET 1 OF 3
TITLE AFT FACING SEAT ASSY, RH		SCALE NTS
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NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3 PRIOR TO INSTALLATION OF SEAT BOTTOM/BACK (D3774-1, -3) AND HEAD RESTS (D412-724-041, -044). MASK FRONT LEGS PRIOR TO POWDER COAT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH D2729-1 RED DECAL ATTACHED TO THE BACK OF SEAT BACK
- 7) WEIGHT: 30.0 lbs
- 8) ITEM 15 (D3774-1 SEAT BOTTOM) AND ITEM 16 (D3774-3 SEAT BACK) REMOVED FOR CLARITY

8

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6

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2

1

D

C

B

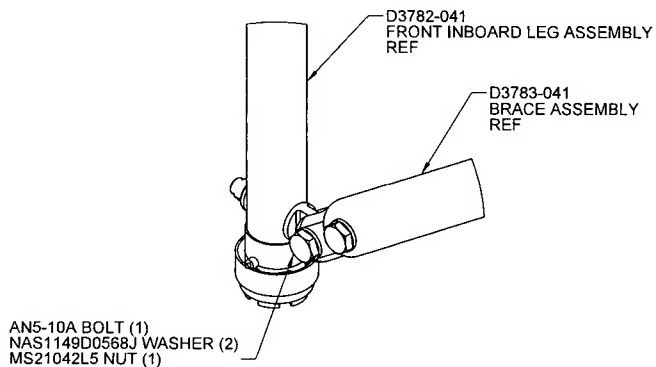
A

D

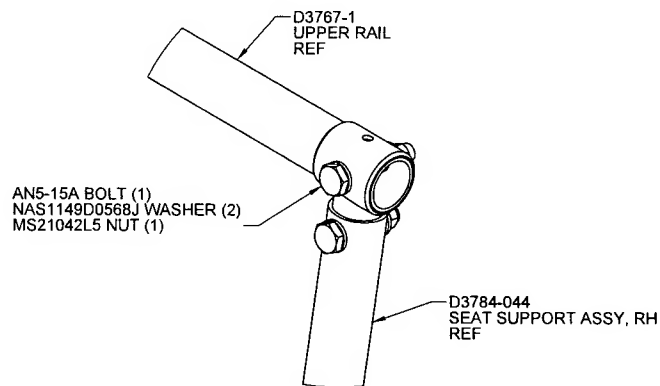
C

B

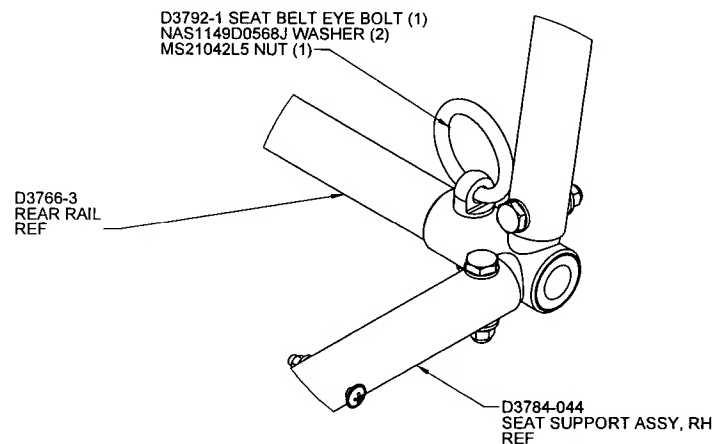
A



DETAIL A
BRACE ATTACHMENT (TYP)



DETAIL C
SEAT SUPPORT END ATTACHMENT (TYP)



DETAIL B
SEAT SUPPORT ATTACHMENT (TYP)

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
06.06.06 RLB

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D412-769-2	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		AFT FACING SEAT ASSY, RH	NTS
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8

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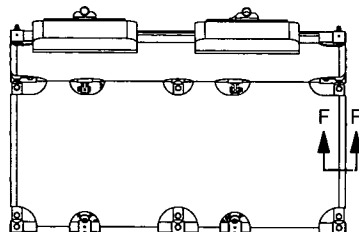
5

4

3

2

1

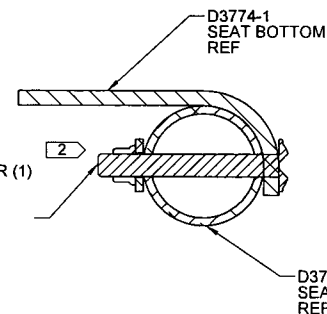


AN525-10R24 SCREW (1)
NAS1149D0363J WASHER (1)
MS21042L3 NUT (1)
TYPICAL
3 PLACES PER SIDE

D3774-3
SEAT BACK
REF

D3784-044
SEAT SUPPORT, RH
REF

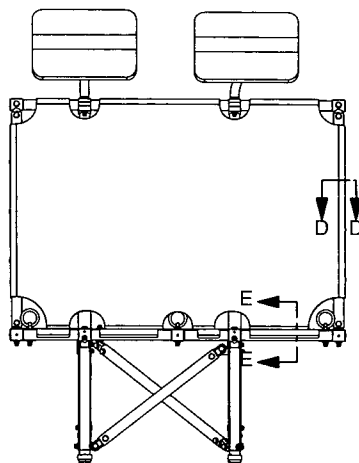
SECTION D-D



AN525-10R24 SCREW (1)
NAS1149D0363J WASHER (1)
MS21042L3 NUT (1)
TYPICAL
2 PLACES PER SIDE

D3784-044
SEAT SUPPORT, RH
REF

SECTION F-F



D3766-2
FRONT RAIL
REF

PROTOTYPE
PLEASE RETURN ALL ISSUED DATA TO ENGINEERING
01.06.06

SECTION E-E

D3774-3
SEAT BACK
REF

D3774-1
SEAT BOTTOM
REF

D3766-3
REAR RAIL
REF

AN3-5A BOLT (1)
NAS1149D0363J WASHER (2)
MS21042L3 NUT (1)
TYPICAL
6 PLACES

NOTES:

- 1) TRANSFER DRILL HOLES $\varnothing 0.201$ FROM SEAT SUPPORTS (D3784-043/-044) TO SEAT BACK (D3774-3) - 3 PLACES/SIDE
- 2) TRANSFER DRILL HOLES $\varnothing 0.201$ FROM SEAT SUPPORTS (D3784-043/-044) TO SEAT BOTTOM (D3774-1) - 2 PLACES/SIDE
- 3) TRANSFER DRILL HOLES $\varnothing 0.201$ FROM SEAT BOTTOM (D3774-1) TO SEAT BACK (D3774-3) - 6 PLACES

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D412-769-2	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		AFT FACING SEAT ASSY, RH	NTS
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8

7

6

5

4

3

2

1

Material Requisitions

CL

R/S#: _____

Part Number: AN52510R22

Batch Number: M107936

Quantity: 20

Required by: AD Date: 080604

Used for

Part Number: 00196

Batch Number: _____

Approved by Purchaser: _____

Date: _____

Comments: _____

T:\TRANSIQ\AMATERIAL REQ-A.DOC

Material Requisitions

CL

R/S#: _____

Part Number: AN525-10R22

Batch Number: M107936

Quantity: 18

Required by: AD Date: 080603

Used for

Part Number: 00196

Batch Number: _____

Approved by Purchaser: _____

Date: _____

Comments: _____

T:\TRANSIQ\AMATERIAL REQ-A.DOC

Material Requisitions

Part Number: MS21042L3

Batch Number: M107644

R/S#: _____

Quantity: 20

Required by: JA Date: 080604

Used for

Part Number: 00196

Batch Number: _____

Approved by Purchaser: _____

Date: _____

Comments: _____

T:\TRANSIQ\A\MATERIAL REQ-A.DOC

Material Requisitions

Part Number: MS21042L3

Batch Number: M107644

R/S#: _____

Quantity: 18

Required by: JA Date: 080603

Used for

Part Number: 00196

Batch Number: _____

Approved by Purchaser: _____

Date: _____

Comments: _____

T:\TRANSIQ\A\MATERIAL REQ-A.DOC

Material Requisitions

Part Number: AN9605D10L

Batch Number: M104885

R/S#: _____

Quantity: 40

Required by: JA Date: 080604

Used for

Part Number: 00196

Batch Number: _____

Approved by Purchaser: _____

Date: _____

Comments: _____

T:\TRANSIQ\A\MATERIAL REQ-A.DOC